

Date: Tuesday, 4/4/2006 1:34:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BELL CRANK
Job Number	: 26524		
Estimate Number	: 11967		
P.O. Number	: N/A	Part Number	: D2056
This Issue	: 4/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2056 REV B2
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B2
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/15/2006
Checked & Approved By	: <u>06.04.04</u>	Qty:	30 Um: Each
Comment	: Est. E 02/04/04 Added Rev.B2 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
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Comment: Qty.: 0.2494 f(s)/Unit Total : 7.4813 f(s)

6061-T6 Bar 1.25 x 1.25"

Material: 6061-T6, 1.250" x 1.250"

Batch: M18742

SD

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 2.80" long

SD 06.05.07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2056

Tumble

Deburr any rough edges after tumbling

IL / SD 06.05.08

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IL / SD 06.05.08

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IL 06/05/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 26/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Tuesday, 4/4/2006 1:34:36 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 26524

Part Number: D2056

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-05-10

(30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-05-15

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/16

(30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST19*

06/05/16

(30)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/17

(30)

Job Completion



in 06-05-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

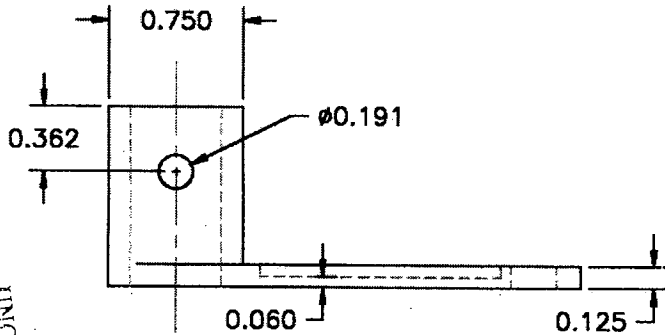
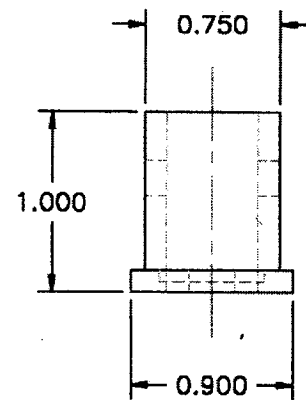
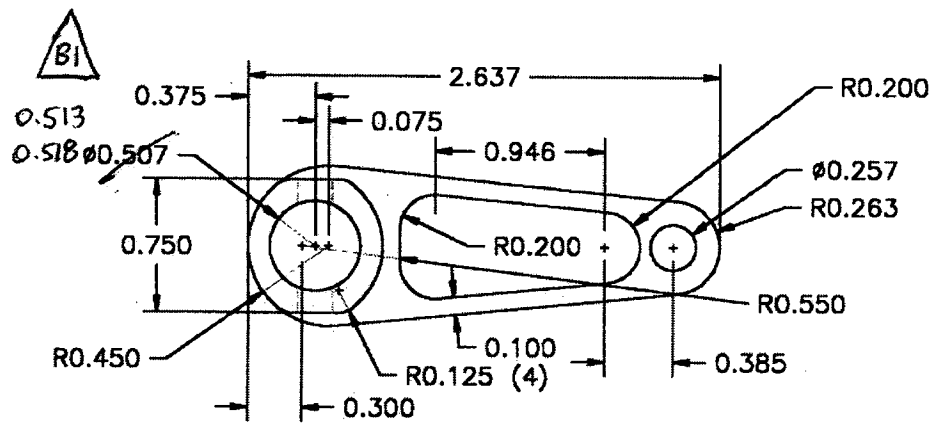
NOTE: Date & initial all entries

DART



RELEASED
99.04.28 AE

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
BW	AE	D2056	
DATE	TITLE	SCALE	
92.03.13	BELL CRANK	1:1	
B	95.11.02	RE-DESIGN	
B1	01.06.04	MODIFY HOLE SIZE, ADD FIL OPTION	
B2	01.12.20	ADD NOTE ON TOLERANCES	



B1 ACID ETCH & ALDINE PER
DART QSE COS 4.1
POWDER COAT BLACK STANDARD
(4.3.5.7) PER DART
QSE COS 4.3

B2

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSE DIB UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26524

Work Order: 26524
Part Number:
Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.637	$\pm .010$	2.640	/			
.750	$\pm .010$.753	/			
$\varnothing .513$	$\pm .005$	$\varnothing .515$	/			
.100	$\pm .010$.106	/			
$\varnothing .257$		$\varnothing .257$	/			
.375	$\pm .010$.374	/			
.750	$\pm .010$.751	/			
$\varnothing .191$		$\varnothing .191$	/			
.060	$\pm .010$.065	/			
.125	$\pm .010$.124	/			
.362	$\pm .010$.366	/			
.750	$\pm .010$.754	/			
1.000	$\pm .010$	1.000	/			
.900	$\pm .010$.901	/			

Inspected by: SA	Audited by: RG	Prototype Approval:
Date: 06.05.08	Date: 06.05.08	Date:
Change Issue	Revised by: KJ/RF	Approved: